

Date: 2/21/2006 9:15 AM
User: Lachelle

Process Sheet

Split

Customer : CU-DART Dart Helicopters Services Drawing Name : CLAMP
Job Number : 25884 -2
Estimate Number : 10107
P.O. Number : N/A Part Number : D2012113
This Date : 2/21/2006 S.O. No. : N/A Drawing Number : D2012 113 REV. C
Project Number : N/A
Project : NC Drawing Revision : C
First Date : N/A Type : PURCHASED PARTS Material : N/A
Previous Revision : 23854 Due Date : 2/28/2006 Qty : 10 Um: Each
Written By : See comment below
Checked and Approved By :
Comments : Est F 01.10.05 Fixed Typo and Added Inspection Level 21 SM

Additional Process:

Job Number



Seq. #: Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 6-1

Laser cut as per Dwg D2012-113

Material: 304/316 SS 0.063" thick

Material release note required

06-02-21

100

2.0 D2012113F CLAMP - FLAT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)
CLAMP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

C 206/03/09 135

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-03-14

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr any rough edges

2- Bend as per Dwg D2012-113 using DT8458

3- Tumble

SB 06/03/20 10

Process Sheet

Job Number: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 25884

Part Number: D2012113



Step #:

Machine Or Operation:

Description:

1.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 17

3.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion:



Jada 10

206/03/20 10

SP 06/03/21 10

W 06-03-21

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 185045 02

Mail To:

ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:

ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Steel: 304

Finish: 2B

Corrosion: ASTM A262/01B; 180 Bend-OK

Your Order: V033868

NAS Order: AE 0249852 03

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/01, A480/01, A666/00, ASMEBA240/01, SA480/01, SA666/01
QQ3766D-A X MC FRM, AMSS513G X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
A96138	* 0415N6 D	.0600	50.0000	4,940	120.0000	SHEET 8	42

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.151	.029	< .001	.395

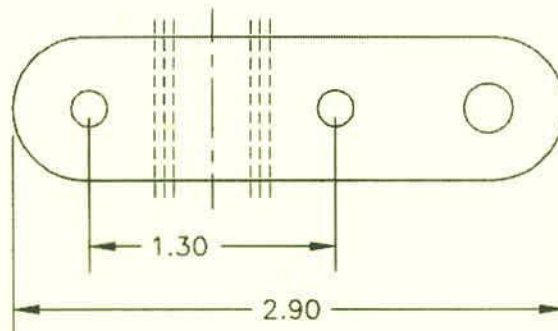
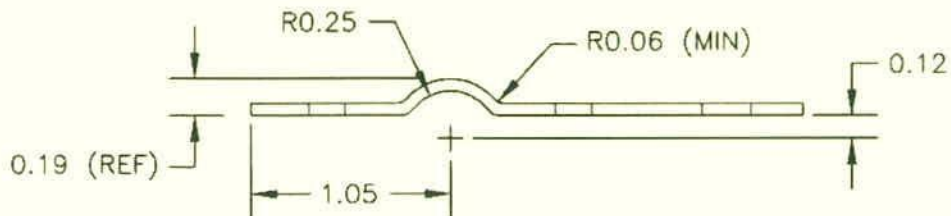
MECHANICAL PROPERTIES

Temp	Yield	Tensile	Elong	Hard	Ball H
70 F	20.0	40.0	25.0	100	110

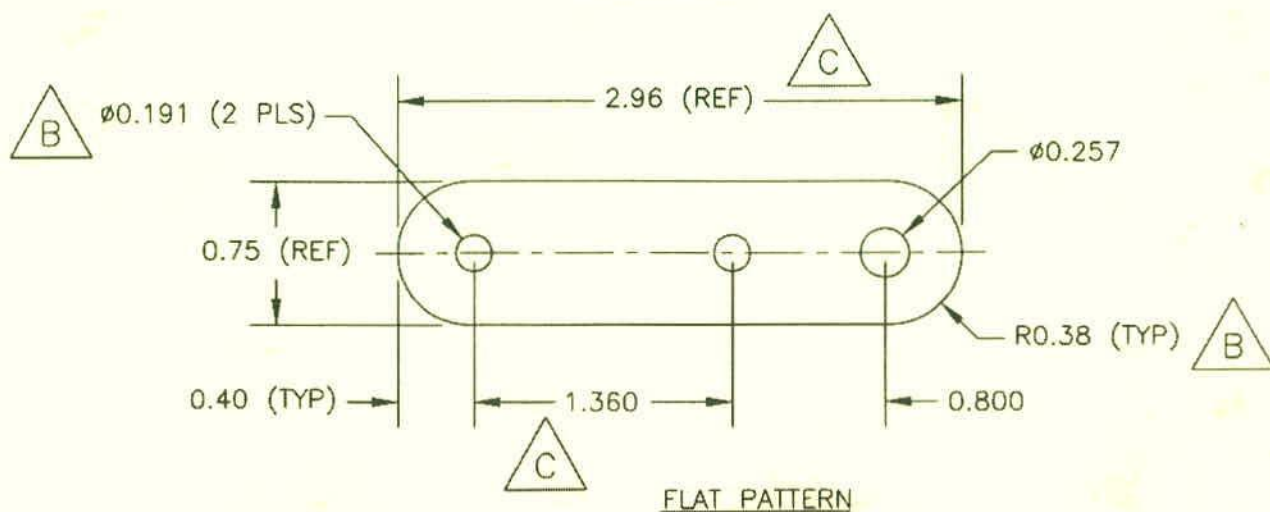


DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-113	REV. C SHEET 1 OF 1
DATE 00.04.28	TITLE CLAMP	SCALE 1:1	
A	92.06.03	REDRAWN FROM D2012	
B	00.02.23	REDRAWN; R0.38 WAS R0.50; $\phi 0.191$ WAS $\phi 0.189$; ADDED FLAT PATTERN	
C	00.04.28	2.96 WAS 3.35; 1.360 WAS 1.745	

RELEASED
00.05.02 *[Signature]*



BENT DETAIL



MATERIAL: AISI 304/316 SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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